

Work Order ID 95810

January-18-13 11:22:53 AM

95810

Page 1

Item ID: D3500-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle

Start Date: 2/18/13

Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/18/13

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date: 13-01-21

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3500

C

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 95810 Double check by: SL 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets
No 2 per Folio FA641 and inspect per attached Dimension Sheets
Step No 3 per Folio FA641 and inspect p

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

PTO

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: dw Date: 13/04/08QA Closed: CK Date: 13/4/12

Work Order: <u>95810</u> Part No. <u>D3500-1</u> NCR No. <u>13-2440</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input checked="" type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	13/3/13	100	1	Dimension 0.550, top hole to edge dim, is 0.005 under tolerance on one part. R.C. OPERATOR ERROR.	GP 13/3/13	CP test assembled saddle with skid & crosstube and fit was very good. Acceptable	GP 13/3/13	S 13/3/13	S 13/3/13
Equip/Tooling <input type="checkbox"/>									
Operator <input checked="" type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misleading
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 95810

January-18-13 11:22:53 AM

95810

Page 2

Item ID: D3500-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle

Stop *NS2*

Start Date: 2/18/13

Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/18/13

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

20 11/13/14

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M124245

320°F

7:45 8:15

20X 0 M/F 13/03/25

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

20X 0 M/F 13/03/25

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 95810

95810

Page 3

January-18-13 11:22:53 AM

Item ID: D3500-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle

Start Date: 2/18/13

Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/18/13

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location

ST 4287

0.00

160

Packaging

Memo

0.00

Packaging

20x

*SP
13-3-26*

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

*13/3/27 JH
MLJ 13-03-26*

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

January-18-13 11:22:53 AM

Page 1

Work Order ID: 95810

Parent Item: D3500-1

Parent Item Name: Saddle

Start Date: 2/18/13

Required Date: 2/18/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013 Saddle Billet		Manufactured	No			100	Each	108.0000	1	20			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT043	8	
60713	8	
MAT045	50	
90316	50	
MAT046	50	
87453	38	
90085	12	

95105 x20

on 13/03/04

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

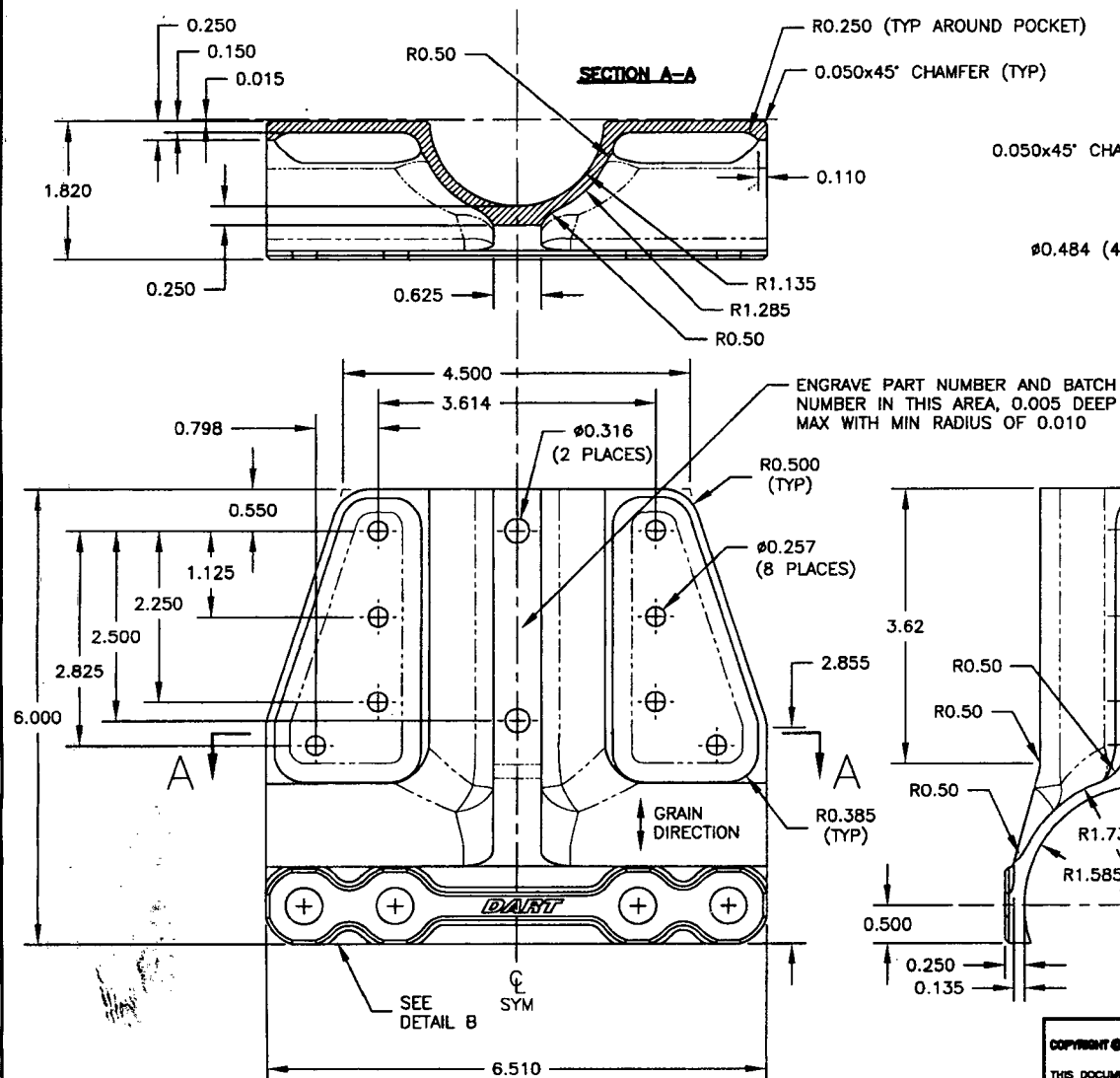
Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
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Setup <input type="checkbox"/>												
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Training <input type="checkbox"/>												
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FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

DART AEROSPACE LTD				Work Order: 95810	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500				Rev: C	
				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.376	0.375	0.375	0.375		
F	0.490	0.510		.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.591	1.5885	1.590		
J	0.240	0.260		.249	.243	.242	.246		
K	0.490	0.510		.500	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	0.317	0.317	0.317		
N	0.256	0.262		.258	0.258	0.258	0.258		
O	6.500	6.520		6.510	6.512	6.512	6.512		
P	5.990	6.010		5.993	5.999	6.006	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.540	.554	0.552	0.552		
V	0.793	0.803		.798	0.798	0.798	0.798		
W	R.240	R.260		.250	0.250	0.250	0.250		
X	0.040	0.060		.050	0.058	0.055	0.050		
Y	0.100	0.120		.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.128	1.132	1.135	1.135		
AB	R.490	R.510		.500	0.500	0.500	0.500		
AC	0.615	0.635		.635	0.635	0.635	0.635		
AD	0.240	0.260		.260	.255	.252	.250		
AE	1.810	1.830		1.821	1.820	1.820	1.820		
AF	0.240	0.260		.253	.254	.251	.248		
AG	0.140	0.160		.150	.154	.151	.152		
AH	0.140	0.160		.158	.160	.156	.156		
AI	0.140	0.160		.160	.151	.159	.159		
Accept/Reject									

Measured by: <i>AK</i>	Audited by: <i>FK</i>
Date: 13/03/04 / 13/03/05	Date: 13/03/13

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD. WINDERMERE, OXFORD, CANADA
CHECKED	PH	DRAWING NO. D3500
DATE	06.06.30	TITLE SADDLE
		REV. C SHEET 1 OF 1 SCALE 2:3

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DART AEROSPACE LTD		Work Order:	93810
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.592	1.5865	1.589		
J	0.240	0.260		0.248	0.246	0.249	0.246		
K	0.490	0.510		0.502	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.552	0.552	0.552	0.552		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.133	1.138	1.135	1.135		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.251	0.252	0.256	0.255		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.251	0.256	0.256	0.255		
AG	0.140	0.160		0.156	0.160	0.160	0.157		
AH	0.140	0.160		0.158	0.153	0.157	0.157		
AI	0.140	0.160		0.158	0.156	0.157	0.157		
Accept/Reject									

Measured by: <u>DA</u>	Audited by: <u>FK</u>
Date: <u>13/03/05</u>	Date: <u>13/03/13</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD				Work Order: 93810	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500				Rev: C	
				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.590	1.5885	1.589		
J	0.240	0.260		.247	.246	.246	.246		
K	0.490	0.510		0.502	0.502	0.502	0.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.552	0.552	0.552	0.552		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.1345	1.135	1.134	1.1345		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		.257	.255	.255	.256		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.256	.256	.255	.254		
AG	0.140	0.160		.156	.157	.156	.156		
AH	0.140	0.160		.156	.158	.156	.157		
AI	0.140	0.160		.158	.158	.158	.157		
Accept/Reject				DAS					

Measured by: D.A.	DAS 14	Audited by: \$ FK
Date: 13/03/06	09 2:29 13/03/07	Date: 13/03/13

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD		Work Order:	95810
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/3	1/4	1/5	1/6	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.589	1.5885	1.589		
J	0.240	0.260		0.246	0.247	0.246	0.245		
K	0.490	0.510		0.507	0.507	0.507	0.507		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.552	0.552	0.552	0.552		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.135	1.135	1.134	1.1346		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.254	0.257	0.255	0.256		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.254	0.255	0.255	0.255		
AG	0.140	0.160		0.155	0.155	0.156	0.155		
AH	0.140	0.160		0.157	0.157	0.158	0.157		
AI	0.140	0.160		0.157	0.159	0.158	0.157		
Accept/Reject									

Measured by: <u>DA</u>	Audited by: <u>FK</u>
Date: <u>13/03/06</u>	Date: <u>13/03/13</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD		Work Order:	93810
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#17	#18	#19	#20	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5886	1.5875	1.589	1.587		
J	0.240	0.260		0.247	0.247	0.247	0.247		
K	0.490	0.510		0.507	0.507	0.507	0.507		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.317	0.317	0.317	0.317		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.552	0.552	0.550	0.548		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.105	0.105	0.105	0.105		
AA	R1.125	R1.145		1.135	1.1346	1.135	1.1335		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.635	0.635	0.635	0.635		
AD	0.240	0.260		0.256	0.257	0.256	0.257		
AE	1.810	1.830		1.820	1.820	1.821	1.820		
AF	0.240	0.260		0.255	0.255	0.257	0.256		
AG	0.140	0.160		0.156	0.155	0.158	0.156		
AH	0.140	0.160		0.152	0.152	0.158	0.158		
AI	0.140	0.160		0.159	0.159	0.159	0.159		
Accept/Reject									

Measured by: DAS	Audited by: F.R.
Date: 13/03/07	Date: 13/03/07

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	